

150

# Work Order ID 69960

Wednesday, May 25, 2011 8:09:08 AM



Page 1

Item ID: D206-642-311BL

Accept



Setup Start



Revision ID:

Item Name: Skidtube LH

Stop



Start Date: 5/25/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date: 11-05-25

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D206-642

Rev N

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-311 CHG006

*Substacy*

*HJ for OL 11-7-6*

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

*Capri*

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

*Substacy*

*QC*

1370937

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 69960**

Wednesday, May 25, 2011 8:09:08 AM



Page 2

Item ID: D206-642-311BL

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube LH

Start Date: 5/25/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-642-311

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

*R**4/2/14*

140

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

*11/7/14**MF 11-07-14*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, May 25, 2011 8:09:15 AM

Page 1

Work Order ID: 69960

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH



Start Date: 5/25/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM/EC  
IPP Rev:K 07-12-04 ECN 1080p DD verified by:ec  
IPP Rev:L 08-09-29 as per DSI9421 DD verified by:EC IPP Rev:M  
as per REV.N DD 10.04.19 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D206-642-341

Manufactured

No

110

Each

3.0000

1

1



Replacement Skidtube



70937

*[Signature]*

Location

Loc Qty

Loc Code

FG082

3

36550

1

44043

1

44044

1

D206-648-013

Manufactured

No

110

Each

10.0000

1

1



GHW Modification



71623

*[Signature]*

Location

Loc Qty

Loc Code

FG120

10

67596

6

68347

4

ATTN: D3414-041 - BLUE

D2932-1

Manufactured

No

110

Each

4.0000

1

1



Saddle LH Out, 206



B71065

*[Signature]*

Location

Loc Qty

Loc Code

ST421

2

67259

2

ST428

2

67790

2

BLUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 2

Wednesday, May 25, 2011 8:09:16 AM

Work Order ID: 69960

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

Start Date: 5/25/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

D2933-1

Manufactured No

110 Each

4.0000

1

1



Saddle LH In, 206

Location

Loc Qty

Loc Code

ST421

4

67260

4

BLUE

D2938-1

Manufactured No

110 Each

4.0000

1



Saddle LH Out, 206

Location

Loc Qty

Loc Code

ST421

4

67261

4

BLUE

D2939-1

Manufactured No

110 Each

5.0000

1



Saddle LH In, 206

Location

Loc Qty

Loc Code

ST421

3

67262

3

ST428A

2

67674

2

BLUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Wednesday, May 25, 2011 8:09:16 AM

Page 3

Work Order ID: 69960

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

Start Date: 5/25/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

AN3-41A

Purchased

No

110

Each

323.0000

8



Bolt



8

Location

Loc Qty

Loc Code

ST354

323

112431

1

115936

72

116191

200

117794

50

D2652

Manufactured

No

110

Each

424.0000

16



Bushing



16

B68102sf

Location

Loc Qty

Loc Code

FG

44

31985

44

ST019

380

67756

180

68941

200

MS21042L3

Purchased

No

110

Each

2,178.000

8



Nut



8

Location

Loc Qty

Loc Code

ST300

2178

116391

11

116540

201

116549

766

117441

800

117601

400

AN960JD10

NAS1149D0363J

Purchased

No

110

Each

0.0000

8



Washer



8

M117291 11/7/7sf

Wednesday, May 25, 2011 8:09:16 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Picklist Print

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Page 4

Work Order ID: 69960

Parent Item: D206-642-311BL


Parent Item Name: Skidtube LH

Start Date: 5/25/2011


Required Date: 6/3/2011

Start Qty: 1.00


Required Qty: 1.00


8 AN5-10A Purchased No 110 Each 304.0000 4 4  
  
 Bolt

Location	Loc Qty	Loc Code
ST337	304	
117313	179	
117795	125	


8 AN5-11A Purchased No 110 Each 92.0000 4 4  
  
 Bolt

Location	Loc Qty	Loc Code
ST337	92	
117313	92	

8 AN960JD516 NAS1149D0563J Purchased No 110 Each 0.0000 8 8  
  
 Washer

8 AN4-6A Purchased No 110 Each 1,099.000 12 12  
  
 Bolt

Location	Loc Qty	Loc Code
ST356	899	
115936	99	
116400	400	
116924	400	
ST358	200	
117514	200	

8 AN960JD416 NAS1149D0463J Purchased No 110 Each 0.0000 25 25  
  
 Washer

Wednesday, May 25, 2011 8:09:17 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Picklist Print

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Page 5

Work Order ID: 69960

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

Start Date: 5/25/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased No

110 Each

4,682.000

12

12



Nut

Location

Loc Qty

Loc Code

ST300

4682

116823

882

117441

3000

~~117601~~

800

D3407-043

Manufactured No

110 Each

19.0000

1

1



Tow Ring

Location

Loc Qty

Loc Code

ST420

2

66386

2

ST464

17

64071

7

68339

10

BLUE

D3456-1

Manufactured No

110 Each

71.0000

1

1



Washer

Location

Loc Qty

Loc Code

FG

7

25701

7

ST054

64

63239

4

66848

6

68748

54

Wednesday, May 25, 2011 8:09:17 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Picklist Print

Wednesday, May 25, 2011 8:09:17 AM

Page 6

Work Order ID: 69960

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

Start Date: 5/25/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

D3457-1

Manufactured No

110 Each

40.0000

2

2



Washer

Location

Loc Qty

Loc Code

FG

10

32409

10

ST054

30

67779

30

MS21043-4

Purchased No

110 Each

1,670.000

1



Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST300

576

117423

576

ST301

1054

115936

40

116549

14

117601

500

117793

500

AN4C5A

Purchased No

110 Each

530.0000

1



BOLT

Location

Loc Qty

Loc Code

FP-B

115

112243

115

ST345

415

112243

415

Wednesday, May 25, 2011 8:09:17 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, May 25, 2011 8:09:17 AM

Work Order ID: 69960

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

Start Date: 5/25/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

AN960C416 NAS1149C0463 Purchased No

110 Each

0.0000

1

1



washer

D3413-1

Manufactured No

110 Each

34.0000

1

1



Ring

Location

Loc Qty

Loc Code

ST420

19

62961

8

66387

11

ST473

15

65294

1

66945

14

BLUE

D2712

Manufactured No

110 Each

451.0000

10

10



Set Screw

Location

Loc Qty

Loc Code

FG

50

29962

50

ST012

252

66955

252

ST021

149

65115

149

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Picklist Print

Wednesday, May 25, 2011 8:09:17 AM

Page 8

Work Order ID: 69960

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

Start Date: 5/25/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

D2934

Manufactured No

110

Each

38.0000

2

2



Saddle Spacer



11/2/7

Location

Loc Qty

Loc Code

FG

6

31929

6

ST027

32

67585

32

D2935

Manufactured No

110

Each

56.0000

2

2



Saddle Spacer



11/2/7

Location

Loc Qty

Loc Code

ST027

56

66564

56

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

REFERENCE ONLY

DART AEROSPACE USA, INC.

D206-642

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4.5 206 L/L-1/L-3/L-4/407 LOW & HIGH GEAR SKIDTUBES

Item	Qty -311	Qty -312	Qty -341	Qty -347	Qty -013	Part Number	Description
	X					D206-642-311	SKIDTUBE INSTALLATION, LH
		X				D206-642-312	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-341	SKIDTUBE
				X		D206-642-347	WEARSHOE KIT (REPLACES -343)
	1	1			X	D206-648-013	GROUND HANDLING KIT
1			1			D2650-5	SKIDTUBE ASSEMBLY
2A			14			D2651-1	* PLUG <sup>(1)</sup>
2B			14			D2651-3	* O-RING <sup>(1)</sup>
3			1			D2646	* AFT CAP <sup>(1)</sup>
4			2			MS27039-1-08	* SCREW <sup>(1)</sup>
5			2			AN960JD10L	* WASHER <sup>(1)</sup>
6	1					D2932-1	SADDLE, FWD OUT, LH
6		1				D2932-2	SADDLE, FWD OUT, RH
7	1					D2933-1	SADDLE, FWD IN, LH
7		1				D2933-2	SADDLE, FWD IN, RH
8	1					D2938-1	SADDLE, AFT OUT, LH
8		1				D2938-2	SADDLE, AFT OUT, RH
9	1					D2939-1	SADDLE, AFT IN, LH
9		1				D2939-2	SADDLE, AFT IN, RH
10	8	8				AN3-41A	BOLT
11	16	16				D2652	BUSHING
12A	8	8				MS21042-3	NUT (OR MS21042L3)
12B	8	8				AN960JD10	WASHER
13	4	4				AN5-10A (OR AN5-11A)	* BOLT <sup>(2)</sup>
14	4	4				AN5-11A (OR AN5-12A)	* BOLT <sup>(2)</sup>
15	8	8				AN960JD516	WASHER
16	12	12				AN4-6A	BOLT
17	24	24				AN960JD416	WASHER
18	12	12				MS21042-4	NUT (OR MS21042L4)
20A			6	6		D3537-1	WEARPAD (REPLACES D2648-3)
21A			1	1		D3537-3	WEARPAD (REPLACES D3429-1)
22A			1	1		D3535-11	WEARSHOE (REPLACES D2656-11)
22B			1	1		D3536-11	GASKET
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)
23B			1	1		D3536-23	GASKET
24A			1	1		D3535-35	WEARSHOE (REPLACES D2656-35)
24B			1	1		D3536-35	GASKET
26A			54	54		MS27039C1-08	SCREW
26B			54	54		AN960C10L	WASHER
26C			54			ALS7-1032-130	* INSERT <sup>(1)</sup> (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1				D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
31	1	1				D3456-1	WASHER
32	1	1				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34	1	1				AN4C5A	BOLT
35	1	1				AN960C416	WASHER
36	1	1				D3413-1	RING (REPLACES D2655)
37	10	10				D2712	SET SCREW
38	2	2				D2934	SADDLE SPACER
39	2	2				D2935	SADDLE SPACER
40					2	D3414-041	GHW LUG (REPLACES D2659)
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER

NOTES: <sup>(1)</sup> DENOTES THAT PART IS INCLUDED WITH D2650-5 ASSEMBLY ABOVE

<sup>(2)</sup> CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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Revision: N

Date: 09.09.09